

Alu. 20.500"

Work Order ID 77292

\*77292\*

Thursday, December 01, 2011 12:52:18 PM

Page 1

Item ID: D2809

Accept

\*N9000040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Bushing

Stop

\*NS2\*

Start Date: 12/1/2011 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 12/8/2011 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-12-01

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2809

Rev A1

100

0.00

\*100\*

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA204

20

0

SL 11/12/03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

20

0

SL 11/12/03

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

B.A 11/12/03

20

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 77292

**\*77292\***

Page 2

Thursday, December 01, 2011 12:52:18 PM

Item ID: D2809 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bushing  
 Start Date: 12/1/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 12/8/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	Chemical Conversion Coat per QSI005 4.1	0.00							
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**\*140\***

HandFinish

Hand Finishing

160

QC3- Inspect Part Finish

**\*160\***

QC

Quality Control

170

Identify as per dwg & Stock Location



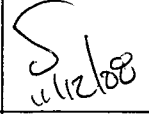
**\*170\***

Packaging

Packaging

*Handwritten notes:*

- m 11/9/480*
- 145. Powdercoat white*
- Start: 8-30*
- Temp: 320*
- End: 4-00*
- 0.00*
- 20 BL 11-12-5.*
- 20 X 11/12/07*
- 20 BL 11-12-7.*
- 20 X 11-12-05*
- 20 X 11-12-05*
- Need please!*

W/O: 77292		WORK ORDER CHANGES						
DATE	STEP	Procedure Change	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/12/05	145	Add. powder coat white start — Fin — temp —		11.12.08			 11/12/08	

Part No: D2809      PAR #: \_\_\_\_\_      Fault Category: \_\_\_\_\_      NCR: Yes No      DQA: \_\_\_\_\_      Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_      Disposition: \_\_\_\_\_      QA: N/C Closed: \_\_\_\_\_      Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**\*77292\***

Thursday, December 01, 2011 12:52:18 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/1/2011      **Start Qty:** 20.00

**\*20\***

**Cust Item ID:**

**Required Date:** 12/8/2011      **Req'd Qty:** 20.00

\*20\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.**  
**Stam**

0.00

**\*180\***

QC

## Memo

0.00

Quality Control

MF  
11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, December 01, 2011 12:52:18 P

**Comments:** IPP C02.03.07Now turned in houseNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No			100	f	217.6100	0.0995	2.0947368			
6061-T6 Round Bar .500"													
										2.242			SL 11/12/03
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT012		217.61							
				114488		4.322				2.242			
				117379		9.288							
				119043		204							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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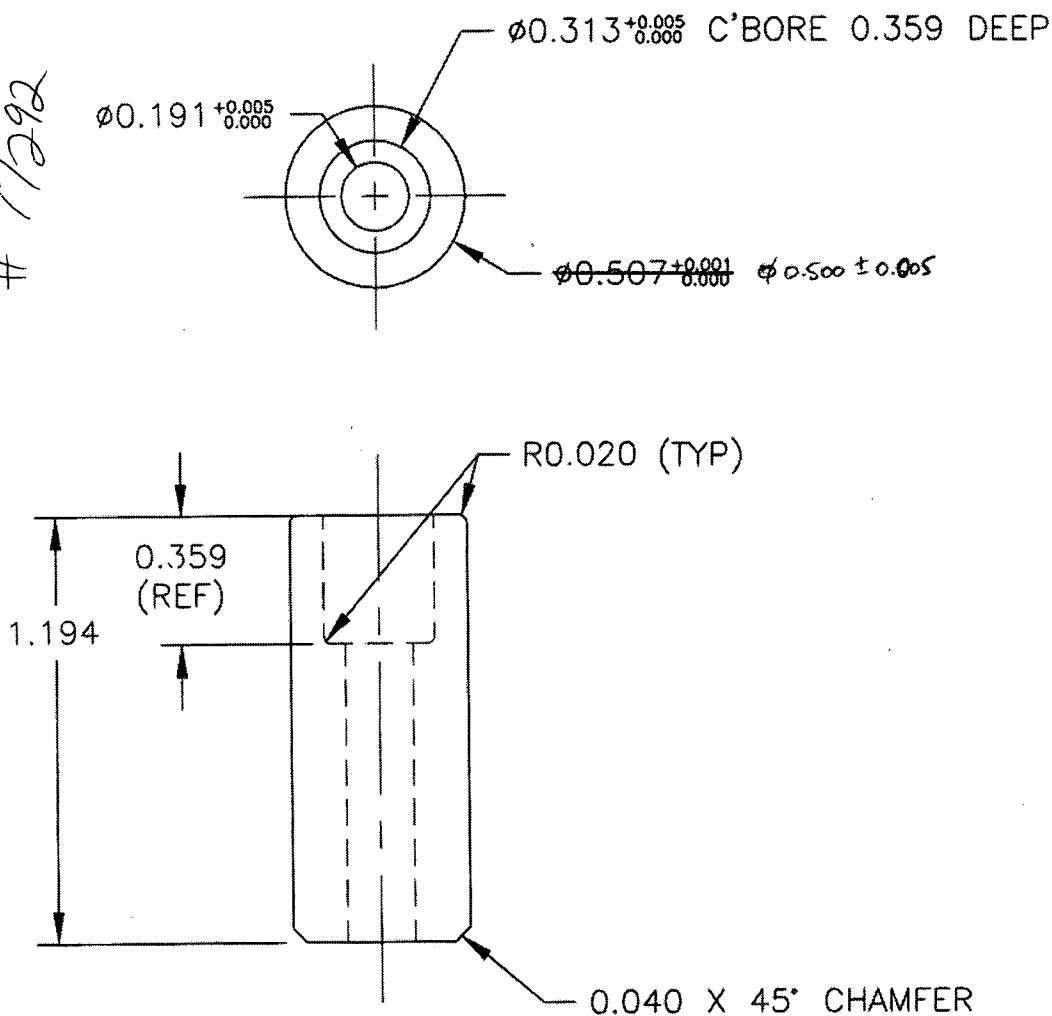




DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	# CP 01.04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED  
00.11.13

# 77292



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020  
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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